

Work Order ID 70616



Page 1

Monday, June 13, 2011 12:34:31 PM

Item ID: D3302-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: HDate: 6/10/13

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3302	Rev B2

100



FLOW WATER JET

Waterjet

Memo

0.00

B11-6-23

FLOW CNC Waterjet

6661.0631-Cut as per Dwg D3302 Dwg Rev: B1 Prog Rev: B2 2-
Deburr if necessary(6)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

B11-6-23

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

8 May (2)X6

Dart Aerospace Ltd

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70616

Monday, June 13, 2011 12:34:31 PM



Page 2

Item ID: D3302-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

130



Small Fab

Small Fab

Small Fab

140



Brake NC

Brake NC

150



QC

Quality Control

NC BRAKE

Memo

Form as per Dwg D3302

0.00

0.00

0.00

0.00

SP 1166129

8 1166129

(6)

(16)

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

0.00

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70616

Page 3

Monday, June 13, 2011 12:34:31 PM

Item ID: D3302-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



HandFinish

Hand Finishing

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

6

BK 11-8-4.

0.00

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

6X Ø M-11/07b4

Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location: 143

0.00

Memo

0.00

11/7/4 625

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70616

Monday, June 13, 2011 12:34:31 PM



Page 4

Item ID: D3302-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 12:34:39 PM

Page 1

Work Order ID: 70616



Parent Item: D3302-3



Parent Item Name: Doubler

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 04.09.02 New issue KJ/JLM
IPP B 06.05.02 Water jet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	285.0000	0.9931	6.272211			

6061-T6 .063 Sheet



Location	Loc Qty	Loc Code
MAT021	285	
116308	29	
117285	256	117285

1311-6-23

(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70616
Description: Doubler	Part Number:	D3302-3
Inspection Dwg: D3302	Rev: B2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	TB	Audited by:	S	Prototype Approval:	N/A
Date:	11-6-23	Date:	10/04/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev update; Dimensions revised to revision B2	KJ/JLM	
C	07.01.16	Dimensions revised	KJ/JLM	
D	07.01.29	Dimensions revised	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

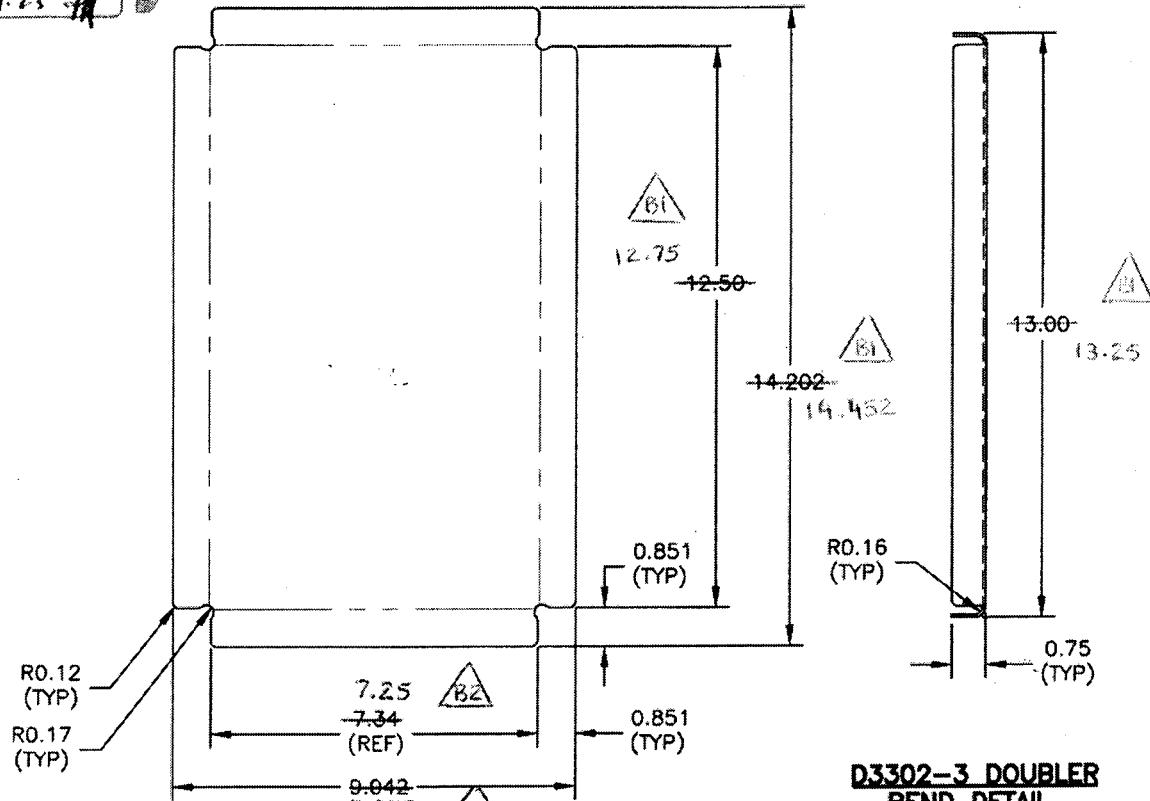
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



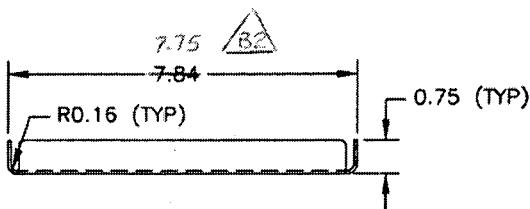
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3302	SHEET 2 OF 4
DATE		TITLE	SCALE
04.11.18		DOUBLER	1:4

RELEASED
04.11.23



D3302-3 FLAT PATTERN

D3302-3 DOUBLER
BEND DETAIL



D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70016

PL 11-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries